

57LIT

## Process Sheet

: CU-DAR001 Dart Helicopters Services

Drawing Name : B-R

Job : 25939 **B**

Estimate : 10390

P.O. : **NIA**This : 2/24/2006 S.O. No. : **NIA**

Pre : NC

Fin : **NIA** Type : MACHINED PARTS

P : 25459

Part Number : D319-041

Drawing Number : D319-041/A1

Project Number : N/A

Drawing Revision : A1

Material : **NIA**

Due Date : 3/30/06

22

30 Um:

Each

ved By

: SEE COMMENT BELOW: SEE ABOVE USER & DATE

: Est Rev: A New Issue 05-11-08 JLM



Machine Or Operation:

Description:

1. M7075T73R1000

7075-T73 Round Bar 1" OD



Comment: Qty.: 2.5410 f(s)/Unit Total: 76.2300 f(s)

Material: 7075-T73 (QQ-A-200/11) or (QQ-A-225/9) 1" OD

(M7075T73R1000)

Identify for D3197-1

Batch: **M 100286****J.F. 06/03/13****22**

2. BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks: 29.125" long

**J.F. 06/03/13****22**

3. HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Face ends to length per dwg D3197

2-Machine D3197-1 as per Folio FA340 and Dwg D3197

3-Deburr

**J.F. 06/03/13 22****SA 060227**

4. QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

**SA 060227**

5. LATHE CONV.

CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE

Chamfer as per Dwg D3197

**J.F. 06-07-13****22**

# Process Sheet

Customer: CU-DAR001 Part Helicopters Services

Drawing Name: BAR

Material: 25939

Part Number: D3197041

Job Number



Seq #

Machine Or Operation:

Description:

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

30 06.03.13

22

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

541 06.03.14

22

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DL 06/03/21

22

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MA 06 03 21

22

10.0

D26905

Lanyard ass'y



Comment: Qty.: 2.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 D2690-5

Lanyard

B25945 (34)

B25475  
B25104

11.0

D32421

Tag



Comment: Qty.: 2.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3242-1

TAG

B25400

B25966 (15)

12.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 360.0000 Each(s)

Pick:

Qty Part Number

Description Batch

12 AN960JD10


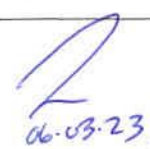

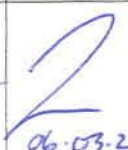
Washer

H19521



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Chief Eng / Prod Mgr	Appr QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-03-23	16	4 x D2690-5 lanyards came undone out of the loop sleeves. The cable also frayed on the ends and were not able to fix. P		Scrap and destroy 1 lanyard pack. And replace B <u>25475</u> show employee how to properly assemble lanyards.	SAD 06:03:23	 06-03-23	 06-03-23	 06-03-23

NOTE: Date & initial all entries

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 25939

Part Number: D3197041

Job Number:



S. J. #: Machine Or Operation:

Description :

13.0

DARS004

Pip Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 JE806-206

DARS-004

Pip Pin

M100259

14.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 MS21042L3

Nut (or -3)

M18917

15.0

MS27039124

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 MS27039-1-24

Screw

M19391

SAD

06:03:24

22

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3197-041 as per Dwg D3197

SAD

06:03:22

22

17.0

QCS

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Feb. 03. 23

22

bars

PTO

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST/37

4/3/24

(22)

19.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

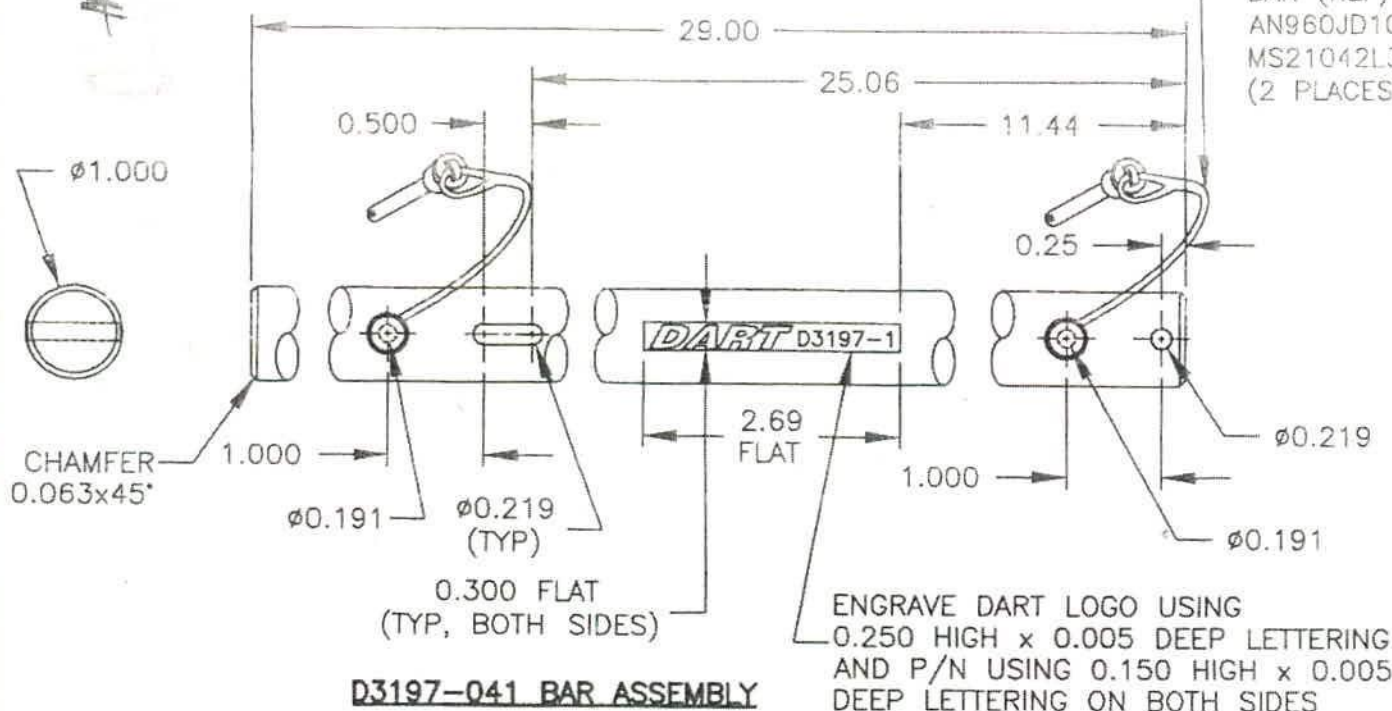
Inspection Level 21

06/03/28

06/03/27







- D3242-1 TMC (1)  
DARS-004 PIP PIN (1)  
MS27039-1-24 BOLT (1)  
AN960JD10 WASHER (1)  
D2690-5 LANYARD (1)  
AN960JD10 WASHER (1)  
BAR (REF)  
AN960JD10 WASHER (1)  
MS21042L3 NUT (1)  
(2 PLACES)

**DART**

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. A
03.07.01	BAR	SHEET 1 OF 1
A	NEW ISSUE	SCALE
A1	ADD D3242-1 TMC	1:1

#### D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9)  $\phi 1.000$  O.D.  
(REF DART SPEC. M7075T73R1.000)
- 2) POSSIBLE SUPPLIER FOR DARS-004 PIP PIN: REID TOOL SUPPLY.  
IT IS ACCEPTABLE TO REPLACE WITH ANY STAINLESS STEEL DOUBLE-ACTING QUICK-RELEASE PIN WITH A  $\phi 0.188$  DIAMETER PIN, 1.8"-2.0" GRIP LENGTH, MIN. OF 200 lbs PULL-OUT STRENGTH, AND MIN. OF 5150 lbs DOUBLE SHEAR.
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR